

Date: Wednesday, 06/09/2006 11:05:06 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: GPS RECEIVER HOUSING
<b>Job Number</b>	: 28418		
<b>Estimate Number</b>	: 12492		
<b>P.O. Number</b>	: N/A	<b>Part Number</b>	: D35143
<b>This Issue</b>	: 06/09/2006	<b>S.O. No.</b>	: N/A
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: UNDER REVIEW <i>E 06.09.05</i>
<b>First Issue</b>	: N/A	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: N/A	<b>Drawing Revision</b>	: N/A
<b>Written By</b>	: <i>EE</i>	<b>Material</b>	: N/A
<b>Checked &amp; Approved By</b>	: <i>[Signature]</i>	<b>Due Date</b>	: 13/09/2006
<b>Comment</b>	: Est Rev:A New Issue 06-07-26 JLM	<b>Qty:</b>	1 Um: Each

## Additional Product

PRELIMINARY ISSUE

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6S040	6061-T6 .040 Sheet
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**Comment:** Qty.: 0.4812 sf(s)/Unit Total : 0.4812 sf(s)  
 6061-T6 .040 Sheet  
 (M6061T6S040)  
 Batch: *M19380*

*ml 06 09 07*

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3514  
 Dwg Rev: *Pre1*  
 Prog Rev: *Pre1*

*ml 06 09 07*

①

\*\*\*Ensure Grain Direction is correct\*\*\*\*\*

2-Deburr if necessary

*ml 06 09 07*

①

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE*ml 06 09 07*

①

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK*SA 06 09 07*

①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DP Date: 02/09/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 06/09/2006 11:05:06 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 28418

Part Number: D35143

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Countersink as per Dwg D3514

SB 06/09/14 ①

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE  
Form as per Dwg D3514

SB 06/09/14 ①

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06-09-14 ①

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

g.m 06-09-18 ①

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/1/15 ①

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: 37448

SB 06/09/19 ①

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: Inspection Level 21

SB 06/09/19 ①

Job Completion



W 06/09/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# PRELIMINARY ISSUE

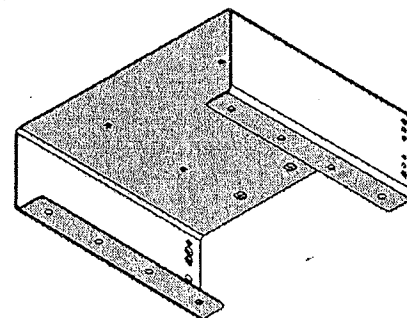
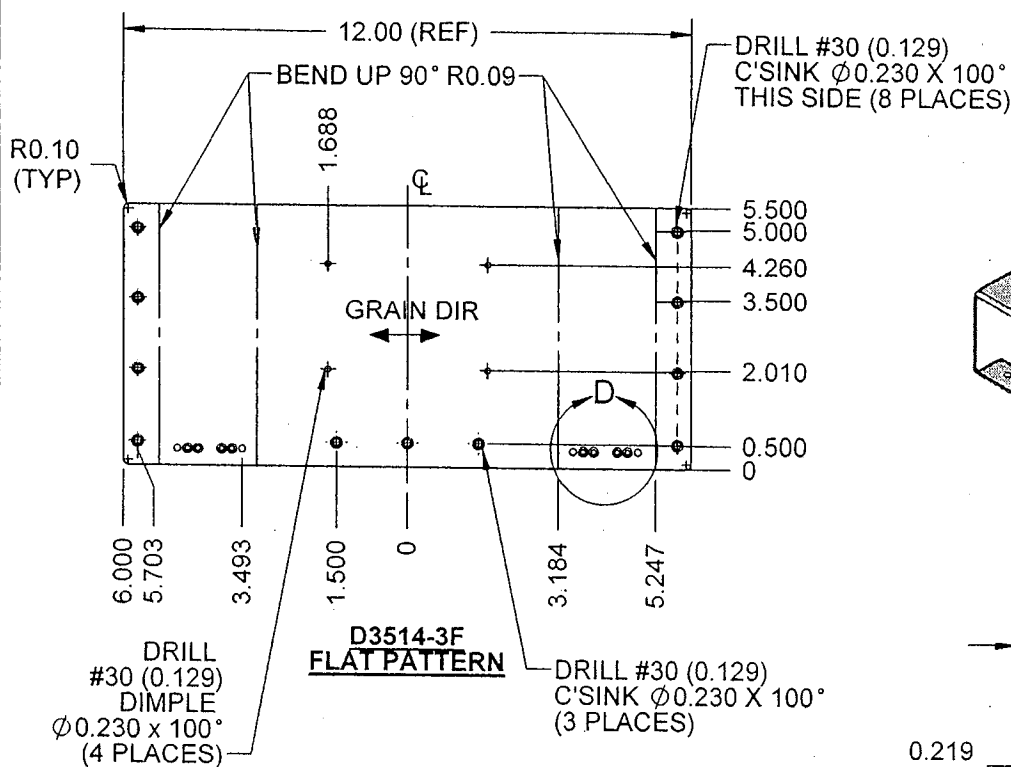
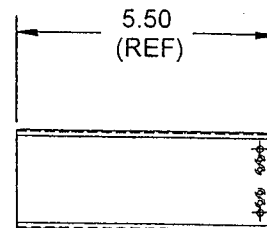
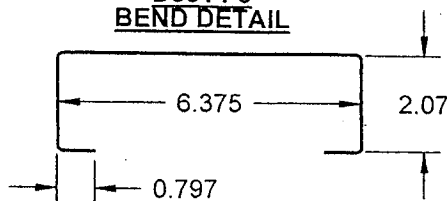
DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3514	REV. A
DATE 06.05.03		TITLE GPS RECEIVER HOUSING	
		SHEET 4 OF 7 SCALE 1:4	

**UNDER REVIEW**

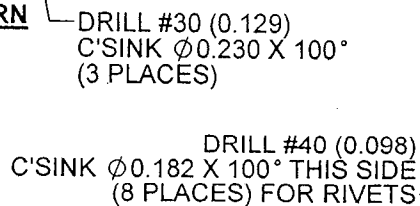
*06.08.22 CB.*

*prototype*

## D3514-3 BEND DETAIL



## D3514-3F FLAT PATTERN



## D3514-3 BOX TOP (TOP MOUNTED)

DETAIL D  
SCALE 1:2

### NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.040 SHEET (REF. DART SPEC. M6061T6S.040)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) SKETCH IS SYMMETRICAL ABOUT  $\phi$
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

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